

**Annexure-M**

**3DS&F TYPE MOVING BLADES MPP**

<b>SL.NO</b>	<b>Operation:</b>	<b>Machine</b>	<b>Dimensions to be Inspected</b>	<b>Remarks</b>
<b>1</b>	Cut the raw material to size (blade length+40mm)	Band saw.	Length.	
<b>2</b>	Roughing of root and profile.	3 Axis CNC	--	
<b>3</b>	Root finish milling.	5 Axis CNC	Dimensions as per drg.	Dimensions to be filled in DIR.
<b>4</b>	Root radius milling.	5 Axis CNC	Dimensions as per drg.	-do-
<b>5</b>	Profile milling (both convex and concave).	5 Axis CNC	Dimensions as per drg.	-do-
<b>6</b>	Taper milling on front profile side.	5 Axis CNC	--	-do-
<b>7</b>	Taper milling on back profile side.	5 Axis CNC	--	-do-
<b>8</b>	Milling of extra material on both ends.	3 Axis M/Cing Centre.	--	-do-
<b>9</b>	Grinding on Shroud and Root transition areas.	Pointed Hand Grinding Tools.	--	-do-
<b>10</b>	Vibro Tumbling.	Vibro Tumbler.	--	-do-
<b>11</b>	Surface finish testing.	Surface Finish Tester.	Surface Finish as per drg.	-do-
<b>12</b>	Final Inspection	3D CMM	All dimensions as per drg.	As per Quality Plan.

**NOTE: Operation No (3-7) are to be done on single setup.**